

Work Order ID 67641

Tuesday, March 29, 2011 8:23:36 AM



Page 1

Item ID: D3211-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 3/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: AL Date: 1103-29

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3211	Rev A1 / DEO								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet
2004 .063

1-Cut as per Dwg D3211 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-
Deburr if necessary

B11-3-30



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 1103/30



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67641

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Revision ID:

Item Name: Bracket

Stop



Start Date: 3/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr

N/A

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Bend D3211-1 Stack as per Dwg D3211

SD 11/03/30

6 (40)

pro

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

SD 11/03/30

(40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3211-1 PAR #: _____ Fault Category: Small Fabs NCR: Yes No DQA: _____ Date: 11/04/06

Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/04/07

NCR: <u>67641</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/03/30</u>	<u>140</u>	<u>1 piece crack at the bend</u> <u>R.C. process.</u>	<u>[Signature]</u>	<u>Scrap - destroy</u> <u>Qty <u>1</u></u>	<u>SB</u> <u>11/03/30</u>	<u>S</u> <u>11/03/30</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>11/03-30</u>

NOTE: Date & initial all entries

Work Order ID 67641

Tuesday, March 29, 2011 8:23:36 AM



Page 3

Item ID: D3211-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 3/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 BL 11-3-30

170

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M115128

Memo

0.00

Powder Coating

START TIME: 10:10

3200 FINISH TIME:

OVEN TEMPERATURE:

10:40

6 BL 11-3-31

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 φ 11-03-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 67641

Tuesday, March 29, 2011 8:23:36 AM



Page 4

Item ID: D3211-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 3/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 211

0.00

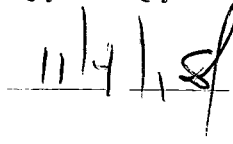


Packaging

Memo

0.00

Packaging

11/4/11  (62)

200

QC21- Final Inspection - Work Order Release

0.00

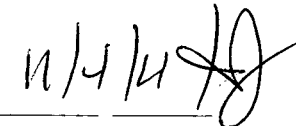


QC

Memo

0.00

Quality Control

11/4/11 
MF

11-04-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 8:23:42 AM

Page 1

Work Order ID: 67641

Parent Item: D3211-1

Parent Item Name: Bracket




Start Date: 3/28/2011

Required Date: 4/1/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-17 JLM
IPP Rev:B Now on Waterjet 06-10-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased	No			100	sf	57.0000	1.405	8.873684		10.43	
2024-T3 .063 sheet												11-3-30	

- Location

Loc Qty

Loc Code

MAT022

57

113867

5

114351

4

117018

48

113867 x2 = 3.81

117018 x3 = 6.62

Ⓢ

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

QA COPY
ISSUED

030115 ~~SECRET~~

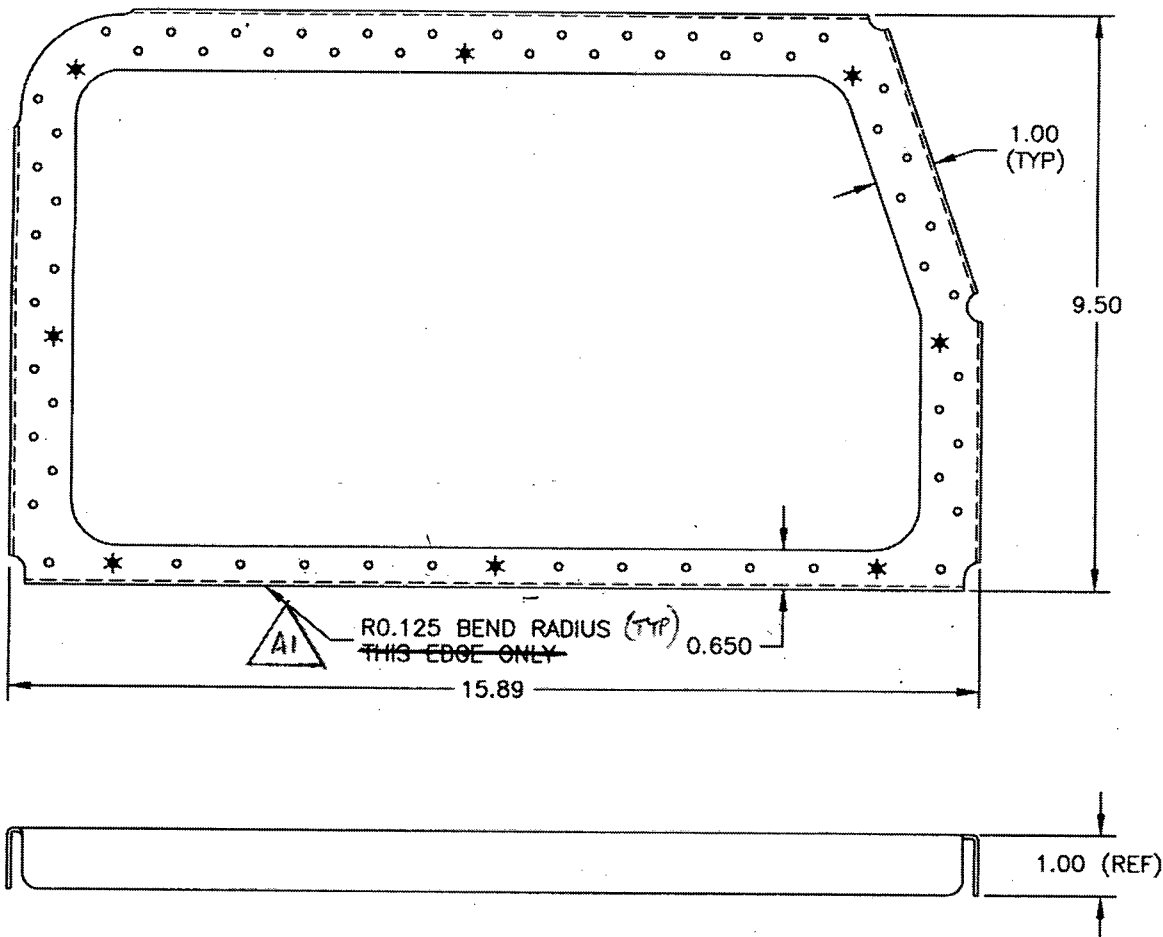
DEO ATTACHED

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. A	
		D3211		SHEET 1 OF 2	
DATE		TITLE		SCALE	
03.09.03		BRACKET		1:3	
A	03.09.03	NEW ISSUE			
A1	03.12.05	CHANGE ALL DIMS FROM TO 120.125			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. C 7144

PH 11-03-25

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

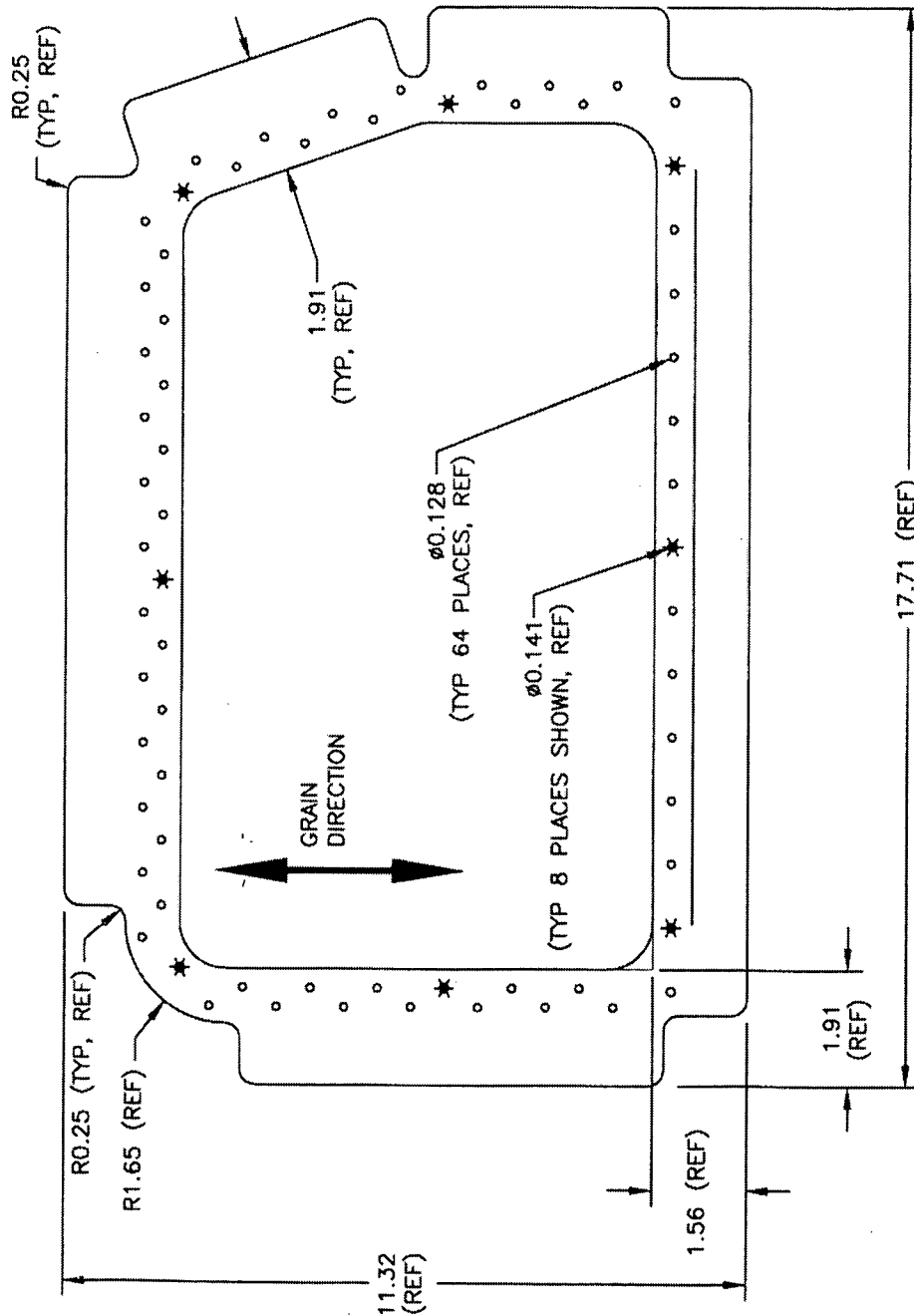


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED
03.09.15

DEO ATTACHED

D3211-1 FLAT PATTERN



u/b 67641

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

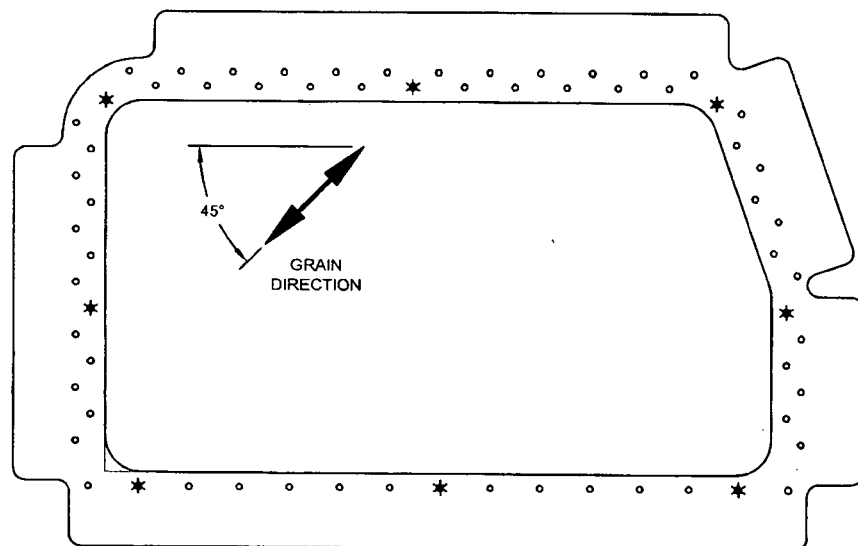
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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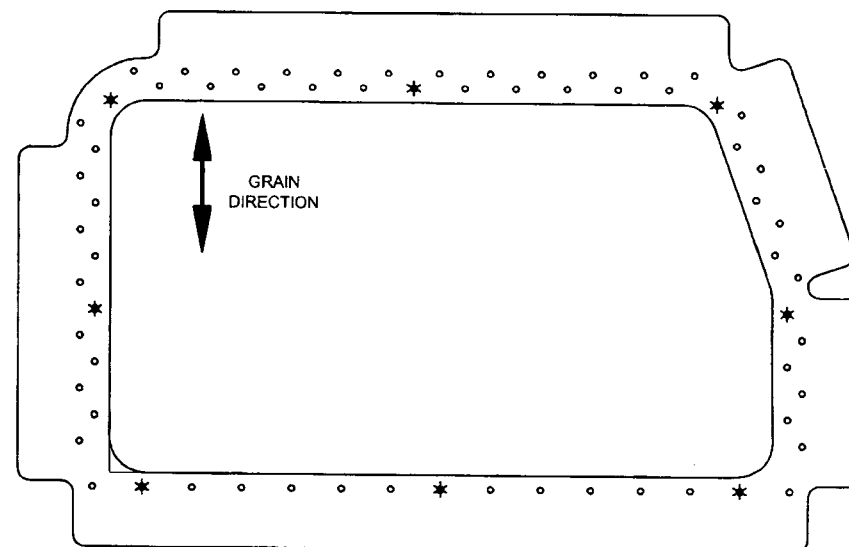
DRAWING NO. D3211	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3211-A-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.09.12	DATE 08.09.12	DATE 08.09.12	DATE 08.09.12		DATE 08.09.12		

SHEET 2 MODIFY GRAIN DIRECTION AS SHOWN BELOW TO FACILITATE BENDING (SEE CAR 08-001).

IS:



WAS:



RELEASED
[Signature]

ALL OTHER INFORMATION REMAINS UNCHANGED

also 4744

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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